

5/30

DART AEROSPACE LTD		Work Order:	23717
Description: Heli-Utility-Basket, Lightweight		Part Number:	D350-721-041
Drawing:		Qty:	1
Ref: IIN-D350-721 Rev. A page 7,8; D3325 Rev. A page 1		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty																																																																																																								
1	DC	Issue Travelers for: D350-721-041 Utility Basket Assy, LH/RH D3324-041 Basket Base Assembly D3325-041 Basket Lid Assembly Drawing not required	Batch 23717 23717 23717	05.06.30	1																																																																																																								
2	DC	Photocopy bluefile and create labels per PPP D350-721-041 CHG001	UK 28	05-07-12	1																																																																																																								
3	WS	Go to Travelers D3324-041 & D3325-041		05/08/03	1																																																																																																								
4	GA	Pick: Assembly Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2022-101</td><td>Spacer</td><td>B21505</td></tr><tr><td>1</td><td>D2332-041</td><td>Prop Assembly</td><td>B23560</td></tr><tr><td>1</td><td>D2530</td><td>Handle Assembly</td><td>B22116</td></tr><tr><td>2</td><td>D2535</td><td>Spring</td><td>B22760</td></tr><tr><td>2</td><td>D2537</td><td>Bushing</td><td>B23839</td></tr><tr><td>1</td><td>D2729-1</td><td>Label</td><td></td></tr><tr><td>2</td><td>D2931</td><td>Bumper</td><td>B21759</td></tr><tr><td>1</td><td>D3320-041</td><td>Webbing</td><td>B23538</td></tr><tr><td>1</td><td>D3351-1</td><td>Label</td><td>B23027</td></tr><tr><td>2</td><td>AN3-16A</td><td>Bolt</td><td>M17073</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M16199</td></tr><tr><td>1</td><td>AN4-20A</td><td>Bolt</td><td>M12082</td></tr><tr><td>1</td><td>AN4-22A</td><td>Bolt</td><td>M15387</td></tr><tr><td>4</td><td>AN5-17A</td><td>Bolt</td><td>M16293</td></tr><tr><td>2</td><td>AN960JD416</td><td>Washer</td><td>M17566</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M3154</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M17614</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M16158</td></tr><tr><td>32</td><td>AN960JD9</td><td>Washer</td><td>M16499</td></tr><tr><td>4</td><td>AN970-4</td><td>Washer</td><td>M16895</td></tr><tr><td>32</td><td>MS20600AD4W23</td><td>Rivet M17123</td><td>M18040</td></tr><tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td>M16931</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3) M15924</td><td>M15924</td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr><tr><td>4</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M16941</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2022-101	Spacer	B21505	1	D2332-041	Prop Assembly	B23560	1	D2530	Handle Assembly	B22116	2	D2535	Spring	B22760	2	D2537	Bushing	B23839	1	D2729-1	Label		2	D2931	Bumper	B21759	1	D3320-041	Webbing	B23538	1	D3351-1	Label	B23027	2	AN3-16A	Bolt	M17073	2	AN4-7A	Bolt	M16199	1	AN4-20A	Bolt	M12082	1	AN4-22A	Bolt	M15387	4	AN5-17A	Bolt	M16293	2	AN960JD416	Washer	M17566	2	AN960JD416L	Washer	M3154	4	AN960JD516	Washer	M17614	2	AN960JD8	Washer	M16158	32	AN960JD9	Washer	M16499	4	AN970-4	Washer	M16895	32	MS20600AD4W23	Rivet M17123	M18040	2	MS20600AD4W3	Rivet	M16931	2	MS21042L3	Nut (or -3) M15924	M15924	4	MS21042L4	Nut (or -4)	M15924	4	MS21042L5	Nut (or -5)	M16941		05/08/17	1
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RC70000366

RELEASED
05-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: FD Date: 05/02/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	<u>23717</u>
Description: Heli-Utility-Basket, Lightweight	Part Number:	D350-721-041
Drawing:	Qty:	<u>1</u>
Ref: IIN-D350-721 Rev. A page 7,8; D3325 Rev. A page 1		Page 2 of 2

Step	Location	Procedure	By	Date	Qty
6	GA	Assemble as per Dwg IIN-D350-721 Attach Travelers: Qty Part Number Description Batch 1 D3324-041 Basket Base Assy <u>23717</u> 1 D3325-041 Basket Lid Assy <u>23717</u>	SAD	05/08/17	1
7	QC5	Inspect for foreign objects as per QSI 024 & Assembly work to Step 6	2	05-08-23	1
8	QC4	Inspect Kit 100% for completeness on the W/O	CY	05/09/06	1
9	PK	Identify and pack for shipping as per PPP D350-721-041 :REV.B	CY	05/09/06	1
10	AC	Cost / part: <u>1780.08</u>	SAC	05-09-07	1
11	DC	Close Work Order and Ensure Travelers Attached Inspect Level 21 <u>1780.08</u> Travelers: D350-721-041 D3324-041 D3325-041	DT	05/09/07	1

Rev	Date	Change	Revised By	Approved
A	04.11.10	New issue	KJ/JLM	
B	05.02.09	Now made in-house	KJ/JLM	
C	05.03.02	Added D3338-1 & D3350-041 to Step 5	KJ/JLM	

RELEASED
05/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 30, 2005
02:06 pm

Work Order No	: 0023717	Department Code:	
Project Name	: D350-721-041	Burden Flags	: NNNNNNNN
Project For	: WK530	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *D350-721-041	Invoice Number	:
Description	: Heli-Utility-Basket, Lwt	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 06-30-05		
Est Finish Date	: 07-30-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

5/30

DART AEROSPACE LTD	Work Order:	23717
Description: Basket Base Assembly	Part Number:	D3324-041
Dwg: D3324 Rev. <i>A B 10/05.05-02</i>	Qty:	1
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																								
1	DC	Issue Traveler Dwg not required	<i>[Signature]</i>	05.06.30	1																								
2	WS	Cut tubes as per Dwg D3324 Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall (M4130N-TS0.500W.035) <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>3</td><td>D3324-1</td><td>Bottom Tube</td><td>M16550</td></tr><tr><td>4</td><td>D3324-3</td><td>Full Length Tube</td><td>M16550</td></tr><tr><td>2</td><td>D3324-5</td><td>Top End Tube</td><td>M17679</td></tr><tr><td>2</td><td>D3324-7</td><td>Bottom EndTube</td><td>M17679</td></tr><tr><td>10</td><td>D3324-9</td><td>Vertical Tube</td><td>M17679</td></tr></table> Identify parts appropriately	Qty	Part Number	Description	Batch	3	D3324-1	Bottom Tube	M16550	4	D3324-3	Full Length Tube	M16550	2	D3324-5	Top End Tube	M17679	2	D3324-7	Bottom EndTube	M17679	10	D3324-9	Vertical Tube	M17679	<i>[Signature]</i>	05/08/04	1
Qty	Part Number	Description	Batch																										
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4	WS	Remove all markings from material	<i>[Signature]</i>	05/08/10	1																								
5	WS	Drill and Weld as per Dwg D3324 & QSI 004 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>Steel Rod</td><td>M19430</td></tr></table>	Qty	Part Number	Description	Batch	A/R	N/A	Steel Rod	M19430	<i>[Signature]</i>	05/08/10	1																
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6	WS	Deburr as required	<i>[Signature]</i>	05/08/11	1																								
7	QC9/6	Inspect welding and dimensions	<i>[Signature]</i>	05-08-11	1																								
8	WS	Take traveler D350-721-041 to KP	<i>[Signature]</i>	05-08-11	1																								
9	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3	FC	05 08 10	1																								
10	QC3	Inspect Powder Coat	MM	03 08 17	1																								
11	FP	To GA for assembly	MM	03 08 17	1																								

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23717
Description: Basket Lid Assembly	Part Number:	D3325-041
Dwg: D3325 Rev. <i>AB 1/16/05 H</i>	Qty:	1
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	AB	05.06.30	1																				
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11	FP	To GA for assembly	ML	05 08 11	1																				

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 05.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____